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- PN - JP5237871 A 19930917
 PD - 1993-09-17
 PR - JP19910098180 19910402
 OPD - 1991-04-02
 AB - PURPOSE: To obtain a foam molded product with a skin by a method wherein after a core part is injection molded using a pair of male and female molds, the female mold is replaced with a female mold having a cavity larger than in thickness than the former one by the thickness of an elastomer layer in an unfoamed state, an elastomer is overlapped on the core part and molded in a full shot, and the molds are slightly opened to make the inner part foam.
 CONSTITUTION: Using a surface of a core mold 1 and a surface of a cavity mold 2 as a set, a core 4 is molded by injecting a fiber-reinforced resin from a nozzle 3-1. After mold opening, the cavity mold 2 is replaced by a skin and foam cavity mold 2-2. After mold closing, an elastomer containing a foaming material is injected from a two layer molding nozzle 3-2 in a full shot. A part of the elastomer in contact with a cavity surface of the cavity mold 2-2 is set in an unfoamed state. After that, the core mold 1 is retracted before the resin in the center part is set, thereby making the center part foam. In this manner, the core 4, a foam 5-2, and a skin 5-1 are molded in the same molds. Therefore, the interior finish material can be obtained with superior appearance and strength.
 IN - SAIKOU TAKAAKI; YOSHIMURA MISAO
 PA - STARLITE IND
 EC - B29C44/08B2
 IC - B29C45/16; B29C45/14; B29K105/04; B29L9/00; B29L31/58
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- TI - Prodn. of interior material for cars - by injection moulding of core, exchanging female mould, then injecting foamable elastomer
 PR - JP19910098180 19910402
 PN - JP5237871 A 19930917 DW199342 B29C45/16 003pp
 PA - (STAR-N) STARLIGHT KOGYO KK
 IC - B29C45/14 ;B29C45/16 ;B29K105/04 ;B29L9/00 ;B29L31/58
 AB - J05237871 A core material is formed by injection moulding using a set of male and female moulds. The female mould is exchanged with a female mould having a cavity which is larger than that of the female mould by a volume corresponding to the thickness of an elastomer layer to be formed. A foamable elastomer added with a foaming agent is full-shot formed such that the elastomer is layered on the core material. After the formation of the elastomer surface layer, the metallic moulds are opened to have a small space, and the foamable elastomer in the metallic moulds is foamed.
 - The core material is ABS, PP, etc. opt. reinforced with glass fibres. The surface layer is styrene, olefin, etc. elastomers contg. a foaming agent.
 - USE/ADVANTAGE - For motocar interiors, e.g., instrument panels, glove boxes. The prodn. is simple. The material has superior appearance, strength, and touch(Dwg.0/2)
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- PN - JP5237871 A 19930917
 PD - 1993-09-17
 AP - JP19910098180 19910402
 IN - SAIKOU TAKAAKI; others: 01
 PA - SUTAARAITO KOGYO KK

- TI - PRODUCTION OF INTERIOR FINISH MATERIAL FOR CAR
- AB - PURPOSE: To obtain a foam molded product with a skin by a method wherein after a core part is injection molded using a pair of male and female molds, the female mold is replaced with a female mold having a cavity larger than in thickness than the former one by the thickness of an elastomer layer in an unfoamed state, an elastomer is overlapped on the core part and molded in a full shot, and the molds are slightly opened to make the inner part foam.
- CONSTITUTION: Using a surface of a core mold 1 and a surface of a cavity mold 2 as a set, a core 4 is molded by injecting a fiber-reinforced resin from a nozzle 3-1. After mold opening, the cavity mold 2 is replaced by a skin and foam cavity mold 2-2. After mold closing, an elastomer containing a foaming material is injected from a two layer molding nozzle 3-2 in a full shot. A part of the elastomer in contact with a cavity surface of the cavity mold 2-2 is set in an unfoamed state. After that, the core mold 1 is retracted before the resin in the center part is set, thereby making the center part foam. In this manner, the core 4, a foam 5-2, and a skin 5-1 are molded in the same molds. Therefore, the interior finish material can be obtained with superior appearance and strength.
- SI - B29K105/04 ;B29L9/00 ;B29L31/58
- I - B29C45/16 ;B29C45/14

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成形工程図、(2)は表皮及び発泡部成形工程図、(3)は発泡工程図、(a)は金型断面図、(b)は成形品部分断面図である。

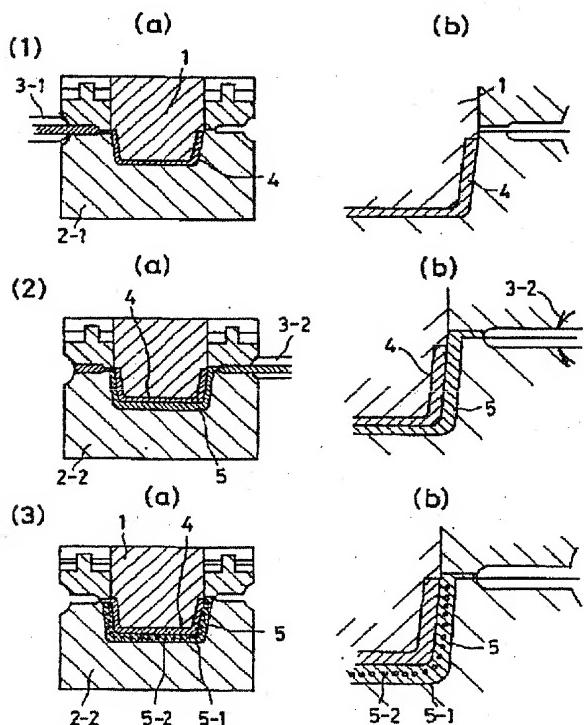
【図2】従来技術たるスラッシュモールドによる二層粉末成形法の工程図である。

【符号の説明】

- | | |
|-----|------------------|
| 1 | コア型 |
| 1-1 | コア型移動部 |
| 2 | キャビ型 |
| 2-1 | 芯材用キャビ型 |
| 2-2 | 表皮及び発泡部二層成形用キャビ型 |
| 3 | 射出ノズル |
| 3-1 | 芯材成形用ノズル |

- | | |
|-----|-------------|
| 3-2 | 二層成形用ノズル |
| 4 | 芯材 |
| 5 | エラストマー層 |
| 5-1 | 表皮部 |
| 5-2 | 発泡体部 |
| 6 | 二層粉末成形金型 |
| 7 | 非発泡性粉末用ボックス |
| 8 | 非発泡性粉末 |
| 8' | 非発泡性粉末成形表皮 |
| 9 | 発泡性粉末ボックス |
| 10 | 発泡性粉末 |
| 10' | 発泡体層 |

【図1】



【図2】

